

Sept 1

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:20:01 AM
User: Linda Lacelle

Process Sheet

SPLIT-1

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : CLEVIS |
| Job Number | : 28189 | | |
| Estimate Number | : 10578 | | |
| P.O. Number | : <u>N/A</u> | Part Number | : D34533 |
| This Issue | : 15/08/2006 S.O. No. : <u>N/A</u> | Drawing Number | : D3453 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <u>N/A</u> Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 27799 | Material | : <u>N/A</u> |
| Written By | : <u>W</u> | Due Date | : 31/08/2006 Qty: 10 Um: Each |
| Checked & Approved By | : <u>W</u> | | |
| Comment | : A 05.09.27 New issue EC | | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304R1250 Inventory



Comment: Qty.: 0.2452 f(s)/Unit Total : 2.4520 f(s)
Material: AISI 304 SS Round Bar Ø1.250
(M304R1.250)
Batch: M101549 29"

MS 06/09/02 4

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-Turn as per Folio FA578 Rev: A & Dwg D3453 Rev: A
2- Deburr as per dwg D3453

new, folio to be made

MS 06/09/02 4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/09/02 4

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1-Mill as per Folio FA578 Rev: AA & Dwg D3453 Rev: A
2- Deburr as per dwg 3453

MS 06/09/02 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/07

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:20:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28189

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/09/07

4

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

ML 06/09/07

4

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/09/07

4

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/09/07

(4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C.L 06/09/07

(4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/09/07

(4)

Job Completion



C.L 06/09/07

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

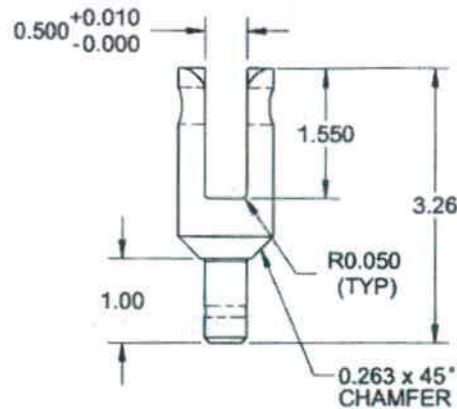
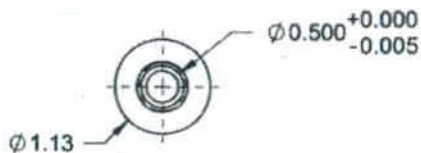
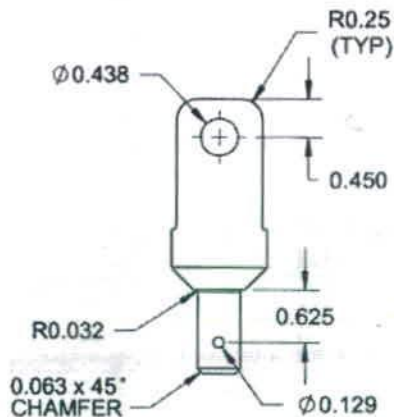
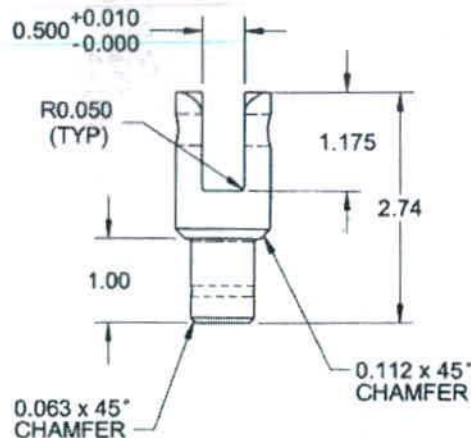
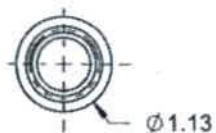
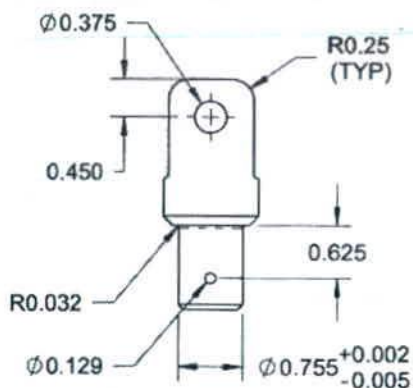

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

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| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D3453 | REV. A SHEET 1 OF 2 |
| DATE 05.09.02 | TITLE CLEVIS | | SCALE 1:2 |
| A | 05.09.02 | NEW ISSUE | |

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****REFERENCE ONLY****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

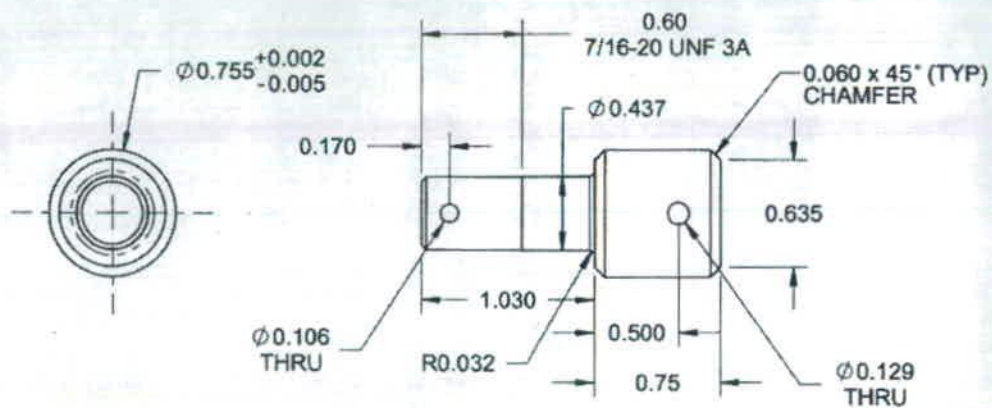
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3453 | REV. A SHEET 2 OF 2 |
| DATE 05.09.02 | TITLE CLEVIS | SCALE 1:1 | |

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

